

ORION® RESINS

Grade: PC/PBTQX7026, PC/PBTQX7026UV
Molding Grade PC/PBT, w/ UV



Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.19	D792
Melt Flow (300°C/1.2 kg)	18.0 g/10 min	D1238
Mechanical		
Tensile Modulus	250,000 psi	D638
Tensile Strength @ Yield	7,100 psi	D638
Tensile Strength @ Break	6,000 psi	D638
Impact		
Notched Izod Impact (73°F, 0.125 in)	12.0 ft-lb/in	D256
Izod Impact, Notched Low Temp (-40°F @ 0.125 in)	10.0 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.250 in)	205 °F	D648

Recommended Processing Guidelines

	Nominal Values
Drying Time and Temperature	3.0 - 4.0 hrs at 250 – 280 °F
Suggested Max Moisture	0.020%
Rear Temperature	450 – 480 °F
Middle Temperature	460 – 490 °F
Front Temperature	460 – 490 °F
Nozzle Temperature	475 – 500 °F
Processing (Melt) Temperature	475 – 500 °F
Mold Temperature	150 – 200 °F

Navigating Custom Compounds